

UNIT LOAD CONSTRUCTION GUIDELINES UNDERWAY REPLENISHMENT OF M548 CONTAINERS

USE THIS DRAWING TO CONSTRUCT UNIT LOADS FOR UNDERWAY REPLENISHMENT OF M548 CONTAINERS WHICH HAVE A GROSS WEIGHT NOT EXCEEDING 166 LBS PER CONTAINER.

THE LOAD SHOWN BELOW & ON PAGE 2 WAS DESIGNED USING THE MAXIMUM CONSTRUCTION PARAMETERS LISTED BELOW. ANY LOAD CONSTRUCTED WHICH DOES NOT EXCEED THESE PARAMETERS IS APPROVED FOR USE.

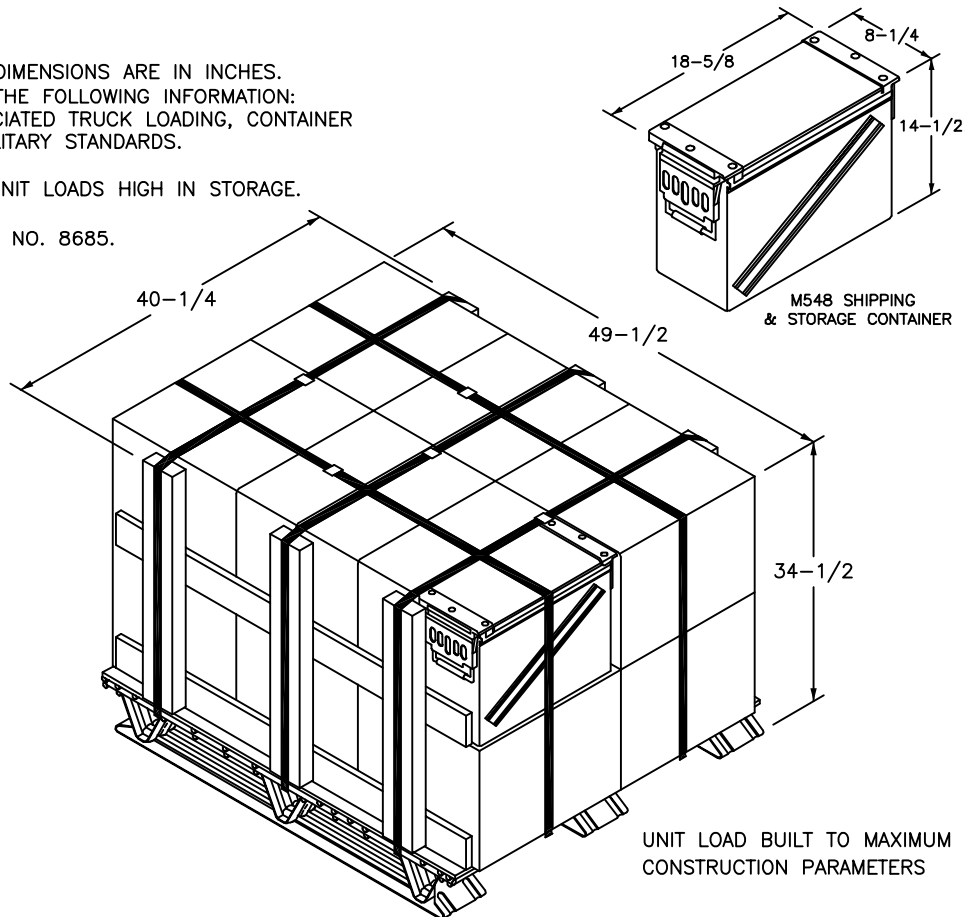
MAXIMUM GROSS WEIGHT OF ONE CONTAINER 166 LBS.
MAXIMUM GROSS WEIGHT OF UNIT LOAD 4,129 LBS.
MAXIMUM NO. OF CONTAINERS 24
MAXIMUM NO. OF CONTAINER LAYERS 2

CUBE OF FULL UNIT LOAD 40.1 CU. FT.
WEIGHT OF EMPTY M548 20 LBS
WEIGHT OF STRAPPING 6 LBS
WEIGHT OF PALLET 94 LBS
WEIGHT OF WOOD (FULL UNIT LOAD) . . . 60 LBS

THE MAXIMUM CONSTRUCTION PARAMETERS LISTED ABOVE MAY BE INCREASED IN THE FUTURE ONLY WHEN A LOAD WHICH FEATURES A PROPOSED INCREASE IN THESE PARAMETERS PASSES ALL TESTING & IS THEN APPROVED FOR USE.

NOTES:

1. UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES.
2. SEE SWO20-AC-SAF-010 FOR THE FOLLOWING INFORMATION:
 - A. CROSS REFERENCE TO ASSOCIATED TRUCK LOADING, CONTAINER LOADING & CAR LOADING MILITARY STANDARDS.
 - B. HAZARD CLASSIFICATION.
3. DO NOT STACK MORE THAN 5 UNIT LOADS HIGH IN STORAGE.
4. FOR UNIT LOAD QUALIFICATION, SEE PHST CENTER TEST REPORT NO. 8685.
5. WOOD COMPONENTS TO BE FREE OF UNSOUND KNOTS AND HOLES, DOUGLAS FIR CLASS 11 OR SOUTHERN PINE CLASS 22, PER NATIONAL WOODEN PALLET AND CONTAINER ASSOCIATION 1800 NORTH KENT STREET, SUITE 911, ARLINGTON, VA 22209-2109, USA.
6. ALL CONIFEROUS WOOD PALLETS AND CONTAINERS PRODUCED OF NON-MANUFACTURED WOOD SHALL BE CONSTRUCTED FROM HEAT TREATED (HEAT TREATED TO 56 DEGREES CENTIGRADE FOR 30 MINUTES) MATERIAL. THE WOOD SHALL BE CERTIFIED BY AN ACCREDITED AGENCY RECOGNIZED BY THE AMERICAN LUMBER STANDARDS COMMITTEE (ALSC) IN ACCORDANCE WITH NON-MANUFACTURED WOOD PACKING POLICY AND NON-MANUFACTURED WOOD PACKING ENFORCEMENT REGULATIONS, BOTH DATED MAY 30, 2001.



A	SEE NSWC IHD DET EARLE ECP I02017	4/19/02	S/AVS	S/RS
-	ORIGINAL ISSUE, SUPERSEDES MIL-STD-1323-187A, -294A, -311A, -333, -335, -368A, -380A, -401, -407, & -412	9/13/99	S/AVS	S/KZ
REV.	REVISION DESCRIPTION	DATE	TDA	SYS COM

TECH DATA MANAGEMENT SUPERVISOR	EP/ S/AVS	9/13/99	DISTRIBUTION STATEMENT A APPROVED FOR PUBLIC RELEASE: DISTRIBUTION IS UNLIMITED REQUIREMENTS FOR CONSTRUCTION OF THIS LOAD SHALL CONSIST OF THIS DOCUMENT & THE LATEST ISSUE OF MIL-STD-1323 (NAVY). THIS LOAD IS AUTHORIZED & RELEASED FOR SHIPPING & STORAGE, TRANSFER-AT-SEA & FOR SHIPMENT BY COMMON CARRIER.	
SYSTEMS ENG. SUPERVISOR	S/GB	9/13/99		
S/K. H. ZIMMS		9/15/99		
NAVSEASYS COM (BY DIRECTION)				
DEPARTMENT OF THE NAVY NAVAL SEA SYSTEMS COMMAND WASHINGTON, D.C., 20362		CAGE CODE 53711	DWG NO. 6214082	REV. A
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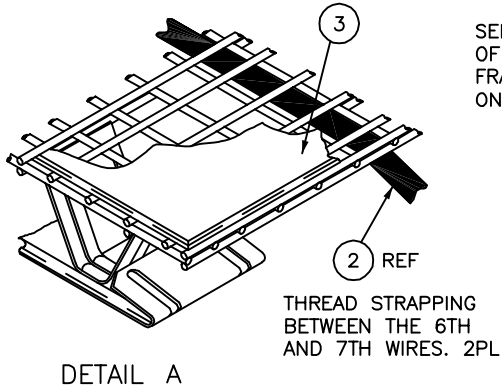
PALLETIZING PROCEDURE FOR UNIT LOAD BUILT TO MAXIMUM CONSTRUCTION PARAMETERS

- (A) FABRICATE TWO SIDE FRAME ASSEMBLIES AS SHOWN IN DETAIL B ON PAGE 3.
- (B) THREAD LONGITUDINAL STRAPS, ITEM 2, THRU PALLET, ITEM 1, AS SHOWN IN DETAIL A.
- (C) POSITION BASE SHEET, ITEM 3, ON PALLET DECK AS SHOWN IN DETAIL A.
- (D) CENTER 24 CONTAINERS ON PALLET.
- (E) BRING LONGITUDINAL STRAPS, ITEM 2, OVER TOP OF UNIT LOAD. TENSION & SECURE EACH STRAP WITH ONE DOUBLE NOTCHED SEAL, ITEM 5.
- (F) POSITION SIDE FRAME ASSEMBLIES AGAINST BOTH SIDES OF UNIT LOAD AS SHOWN BELOW.
- (G) POSITION LATERAL STRAPS, ITEM 4, UNDER PALLET DECK, OVER VERTICAL BATTENS OF SIDE FRAME ASSEMBLIES & OVER TOP OF UNIT LOAD. TENSION & SECURE EACH STRAP WITH ONE DOUBLE NOTCHED SEAL, ITEM 5.
- (H) SECURE LATERAL STRAPS TO VERTICAL BATTENS OF SIDE FRAME ASSEMBLIES USING STAPLES, ITEM 6, IN LOCATIONS SHOWN BELOW (2 STAPLES PER BATTEN).

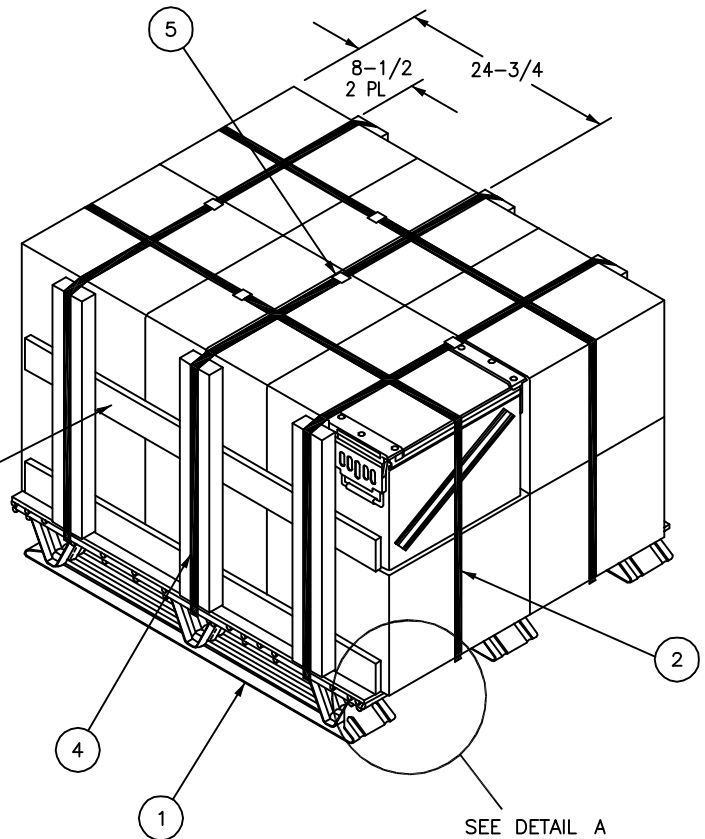
MARKING: IN ADDITION TO ANY SPECIAL MARKING REQUIRED BY CONTRACT OR ORDER, THE UNIT LOAD SHALL BE MARKED IN ACCORDANCE WITH 6214251.

WARNING

WEAR LEATHER GLOVES AND EYE PROTECTION (WITH SIDE SHIELDS) OR GOGGLES TO PREVENT INJURY WHEN PERFORMING STRAPPING OPERATIONS. RAPIDLY UNCOILING STRAPPING MAY CAUSE INJURY. DIRECT STRAPPING AWAY FROM PERSONNEL WHEN CUTTING STRAPPING UNDER TENSION.



SEE DETAIL OF SIDE FRAME ASSY ON PAGE 3.



NOTES:

1. UNLESS OTHERWISE SPECIFIED, ALL MATERIALS SHALL BE IN ACCORDANCE WITH MIL-STD-1323 (NAVY).
2. DO NOT USE TYPE I STRAPPING WITH POWER MACHINES.

DEPALLETIZING PROCEDURE

- (A) REMOVE STAPLES.
- (B) CUT AND REMOVE STRAPPING.
- (C) REMOVE SIDE FRAME ASSEMBLIES.
- (D) REMOVE CONTAINERS.

5	5	SEAL	STEEL	3/4 SIZE
3	4	LATERAL STRAP	STEEL	3/4 X .035 X 13 FT. 6 IN.
1	3	BASE SHEET	PLYWOOD	40 X 48 X 3/4
2	2	LONGITUDINAL STRAP	STEEL	3/4 X .035 X 15 FT.
1	1	PALLET, MK 3 MOD 0	564200	40 X 48 X 4 3/4
REQ'D	ITEM	DESCRIPTION	MAT'L/DWG.	DIMENSIONS

LIST OF MATERIALS

NAVSEA
DWG NO.

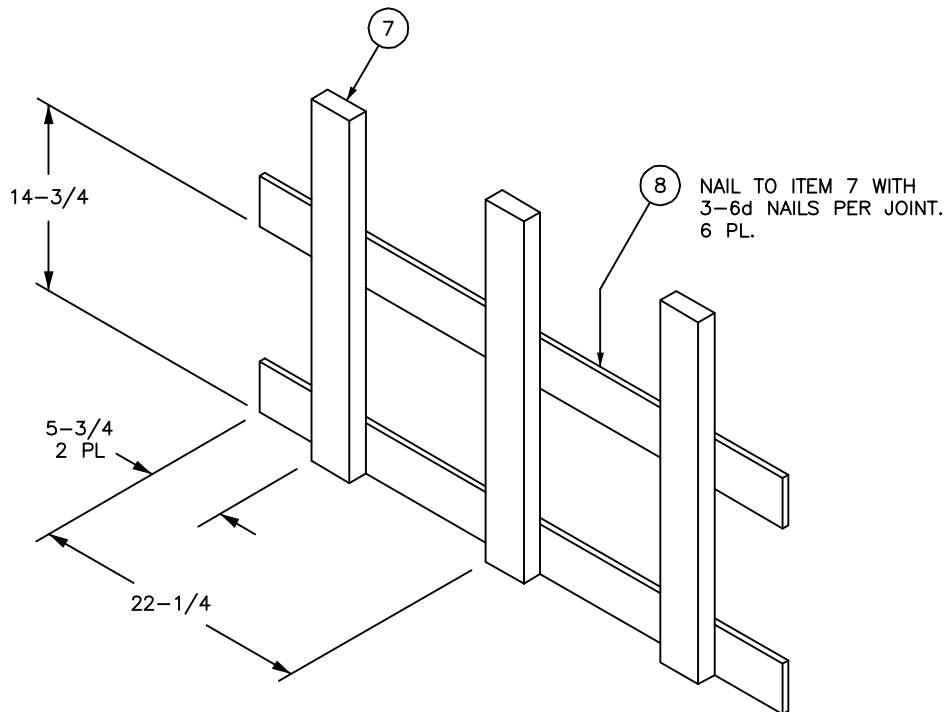
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REV. A

SIZE A

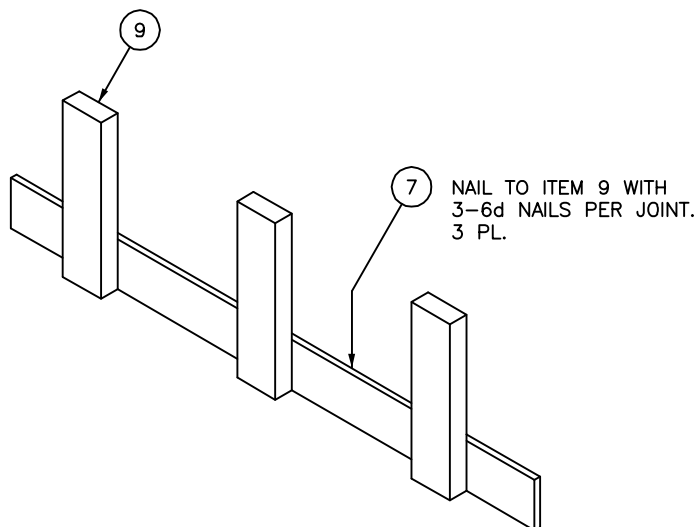
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DETAIL B

SIDE FRAME ASSEMBLY
USED ON TWO LAYER HIGH UNIT LOAD
(2 REQ'D.)



DETAIL C

SIDE FRAME ASSEMBLY
USED ON SINGLE LAYER UNIT LOAD
(2 REQ'D.)

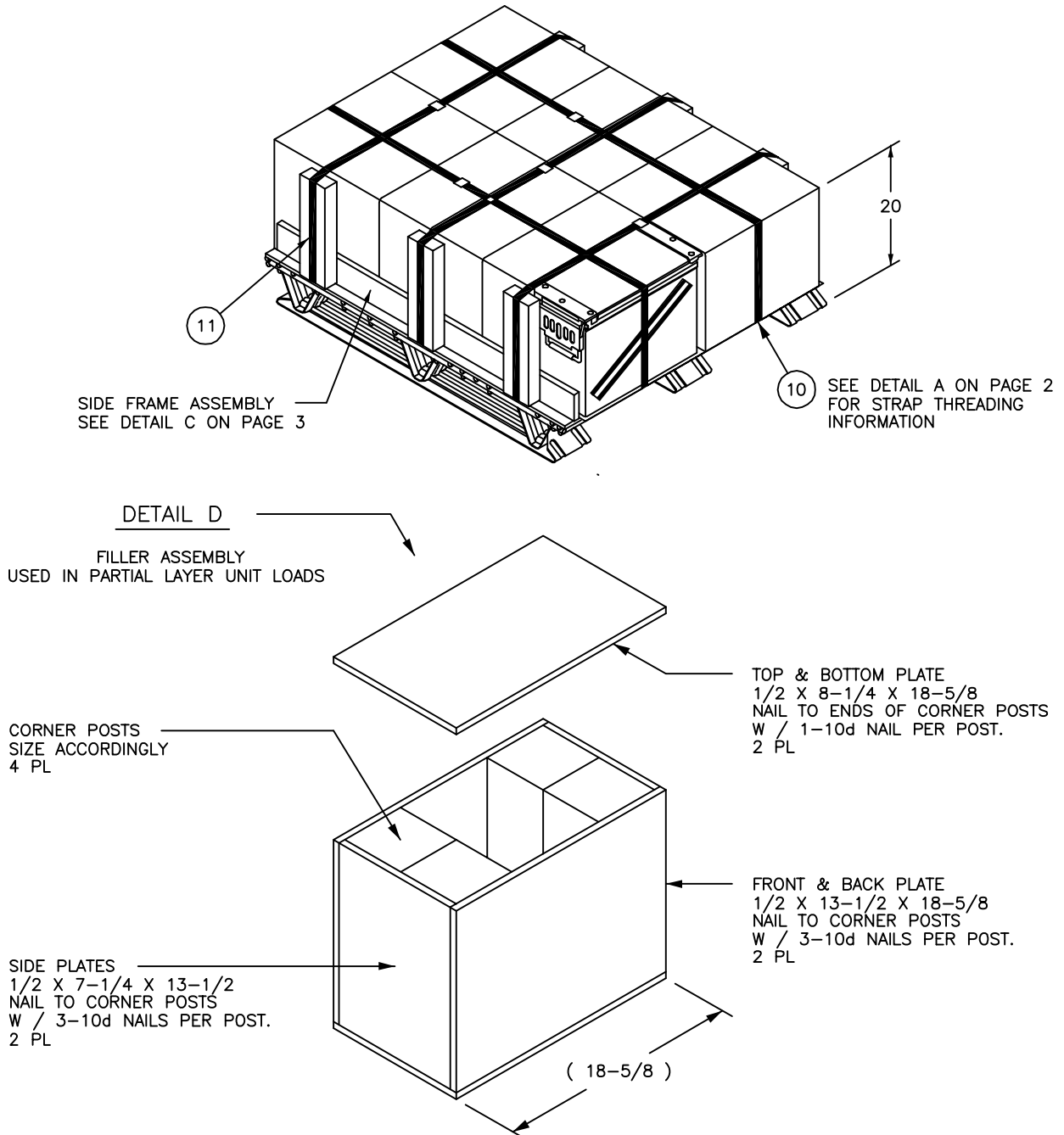
NOTE: SAME CONSTRUCTION AS DETAIL B EXCEPT AS NOTED.

6	9	VERTICAL BATTEN, SINGLE LAYER	WOOD	2 X 4 X 14-1/2
4	8	HORIZONTAL BATTEN	PLYWOOD	1/2 X 4 X 48
6	7	VERTICAL BATTEN, DOUBLE LAYER	WOOD	2 X 4 X 28-3/4
REQ'D	ITEM	DESCRIPTION	MAT'L/DWG.	DIMENSIONS
LIST OF MATERIALS				

PARTIAL UNIT LOAD PROCEDURES

NOTE: SAME CONSTRUCTION AS THE UNIT LOAD SHOWN ON PAGE 2 EXCEPT AS NOTED BELOW.

- (A) PARTIAL UNIT LOADS SHALL BE UNITIZED AS SHOWN BELOW. FABRICATE SIDE FRAME ASSEMBLIES AS SHOWN IN DETAIL C ON PAGE 3.
- (B) FOR PARTIAL LAYERS, USE EMPTY M548 BOXES OR THE ASSEMBLY SHOWN IN DETAIL D AS FILLERS FOR MISSING CONTAINERS. EMPTY M548 BOXES USED AS FILLERS MUST BE CLEARLY MARKED ON THE COVER THAT THEY ARE EMPTY.
- (C) FILLERS SHALL BE POSITIONED AT THE CENTER OF THE UNIT LOAD, NOT ON THE ENDS. IN A TWO-LAYER HIGH PARTIAL UNIT LOAD, ALL FILLERS SHALL BE IN THE UPPER LAYER.



3	11	LATERAL STRAP	STEEL	3/4 X .035 X 11 FT.
2	10	LONGITUDINAL STRAP	STEEL	3/4 X .035 X 12 FT. 6 IN.
REQ'D	ITEM	DESCRIPTION	MAT'L/DWG.	DIMENSIONS

LIST OF MATERIALS

NAVSEA
DWG NO.

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